

Friday, June 04, 2010 11:24:43 AM



Item ID: D5955

Accept

**Setup Start**

Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 6/4/2010 **Start Qty:** 6.00

**Cust Item ID:**

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/6/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59447

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Item ID: D5955

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>MA</u>	<u>10</u>	<u>08</u>	<u>24</u> (6)
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <u>8:45</u> <u>3:00</u> FINISH TIME: <u>9:15</u> <input type="checkbox"/> OVEN TEMPERATURE:	0.00 0.00				<u>6</u>	<u>BL</u>	<u>10-6-25</u>	
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>MA</u>	<u>10</u>	<u>08</u>	<u>25</u> (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 59447

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Page 3

Item ID: D5955

Accept

Revision ID:

Item Name: Saddle, 205

Start Date: 6/4/2010 Start Qty: 6.00

Required Date: 6/10/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 430

0.00



Packaging

Memo

0.00

Packaging

10-6-28

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28

CL10/6/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 11:24:47 AM

Page 1

Work Order ID: 59447



Parent Item: D5955



Parent Item Name: Saddle, 205

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-013		Manufactured	No			100	Each	20.0000	1	6			



Saddle Billet



Location

Loc Qty

Loc Code

MAT47

20

46413

20

6 DIT 10/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 59447
Description: Outer Aft Saddle		Part Number: D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.321	0.321	0.321	0.321		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.505	0.502	0.502		
N	1.865	1.885		1.885	1.885	1.885	1.885		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.251	2.255	2.252	2.252		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.764	0.764	0.764	0.764		
S	0.490	0.510		0.502	0.499	0.506	0.504		
T	1.625	1.645		1.639	1.637	1.636	1.633		
U	2.000	2.020		2.014	2.008	2.011	2.006		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJD
Date: 10/06/22

Audited by: [Signature]
Date: 10.6.23

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

W/O:			WORK ORDER CHANGES					
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R	0.760	0.765		0.764	0.764				
S	0.490	0.510		0.503	0.501				
T	1.625	1.645		1.633	1.632				
U	2.000	2.020		2.005	2.005				
V	0.023	0.043		0.033	0.033				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

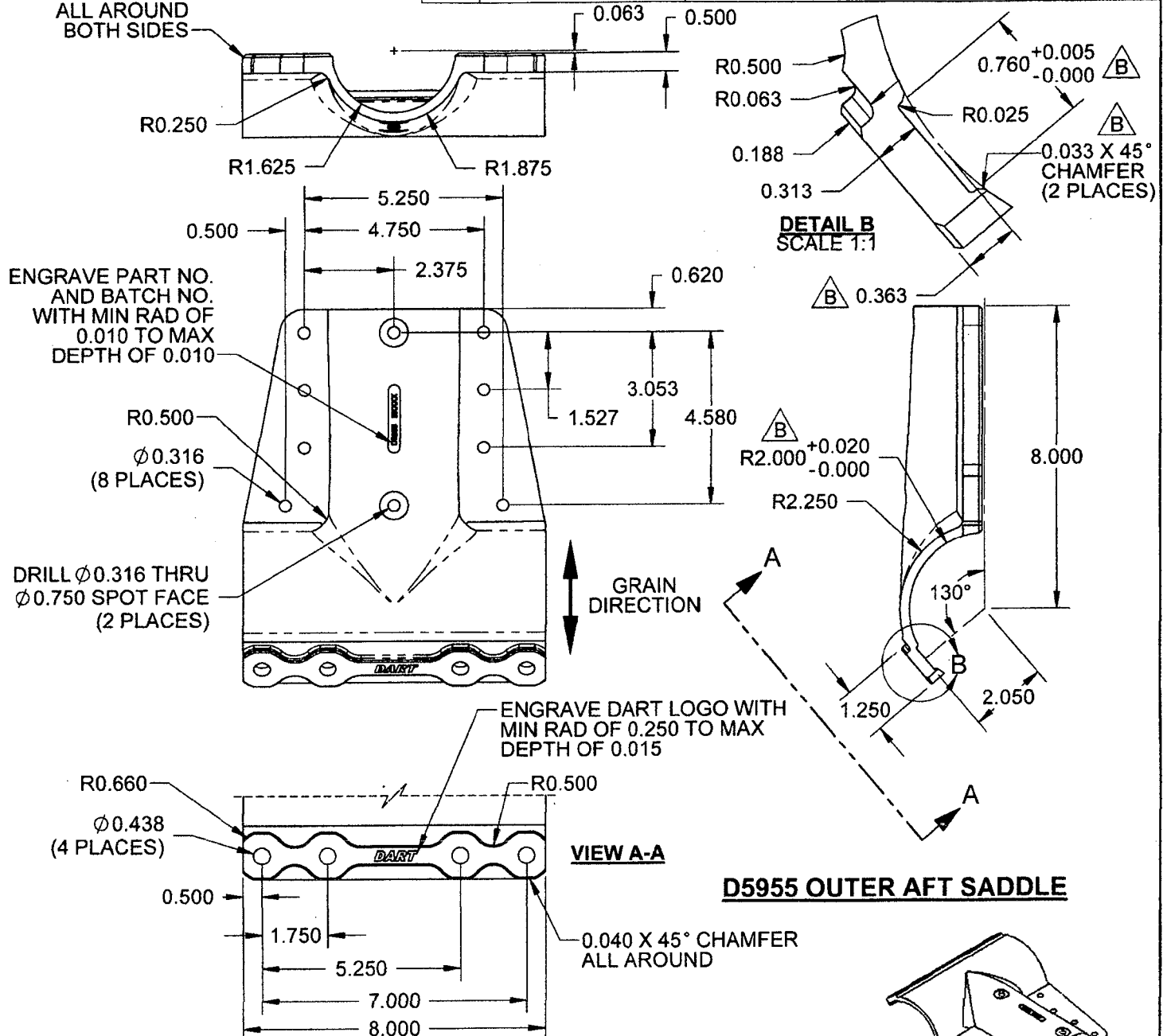
Measured by: DJP
Date: 10/06/23

Audited by: [Signature]
Date: 10.6.23

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F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE		SCALE 1:4
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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